

Work Order ID 64029

Tuesday, November 23, 2010 8:06:51 AM



Page 1

Item ID:	D3914-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Lid Assembly (350)					
Start Date:	11/23/2010	Start Qty:	1.00		Cust Item ID:	
Required Date:	11/30/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-11-29	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3914	B								

100	Weld per dwg A/R S.S. rod Batch: <u>4114649</u>	0.00							
	Large Fab								
Large Fab	Memo	0.00							
	1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg D3914 ***inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***make sure to place mesh correctly on lid, check with label plate before tacking mesh***								

10/11/29 (1x)

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							
	EPL 10.12.01 10.12.01								

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 8/10/12/01 0.00							
130 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo *** mask sides of hinge prior to powdercoat*** Start Time: 11:10 Oven Temperature: 300° Finish Time: 11:40	0.00 0.00				1		10-12-11	
140 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch M115790 Memo Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install placard and label as per dwg	0.00 0.00				1			

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Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 11/23/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>G-A</u>	0.00							
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

EP 10/12/02 ①EP 10/12/02 ①CK 10/12/06DL 10-12-3 ①

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Picklist Print

Tuesday, November 23, 2010 8:06:55 AM

Page 1

Work Order ID: 64029

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 11/23/2010





Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2581  Mounting Bracket		Manufactured	No			100	Each	31.0000	2	2		10/11/25	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		31							
					61953	20							
					63493	11							
✓ D3914-1  Rib		Manufactured	No			100	Each	4.0000	2	2		10/11/25	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		4							
					63609	4							
✓ D3914-7  Rib		Manufactured	No			100	Each	4.0000	2	2		10/11/25	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		4							
					63631	4							
✓ D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	4.0000	3	3		10/11/25	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		4							
					63256	4							

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Page 2

Work Order ID: 64029

Parent Item: D3914-041


Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 11/23/2010

Required Date: 11/30/2010


Start Qty: 1.00

Required Qty: 1.00

✓ D4018-5 Manufactured No 100 Each 33.0000 9 9

 Rib


Location Loc Qty Loc Code

WA 33
 63610 33

* D4020-5 Manufactured No 100 Each 1.0000 1 1

 Mesh (350 Basket Long, Lid)


Location Loc Qty Loc Code

WA 1
 60643 1

✓ D4021-3 Manufactured No 100 Each 1.0000 1 1

 Data Plate


Location Loc Qty Loc Code

WA 1
 56050 1

✓ D4035-041 Manufactured No 100 Each 1.0000 1 1

 Lid Rib Assembly, Fwd (350 Basket)

Location Loc Qty Loc Code

WA 1
 61066 1

✓ D4035-043 Manufactured No 100 Each 1.0000 1 1

 Lid Rib Assembly, Aft (350 Basket)

Location Loc Qty Loc Code

WA 1
 61067 1

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Shop Packet Print

Page 2

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Page 3

Work Order ID: 64029



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D2728-3

Manufactured

No

140

Each

0.0000

1

1



Dart Logo label

M115050



x1 11/10/12/01

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D31-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 614029

BS-11-23

RELEASED
10-08-17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	WJ		
APPROVED	WJ		
DE APPR.	WJ		
DATE	10.08.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 TITLE LONG BASKET LID ASSY (350) REV. B SHEET 1 OF 4 SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

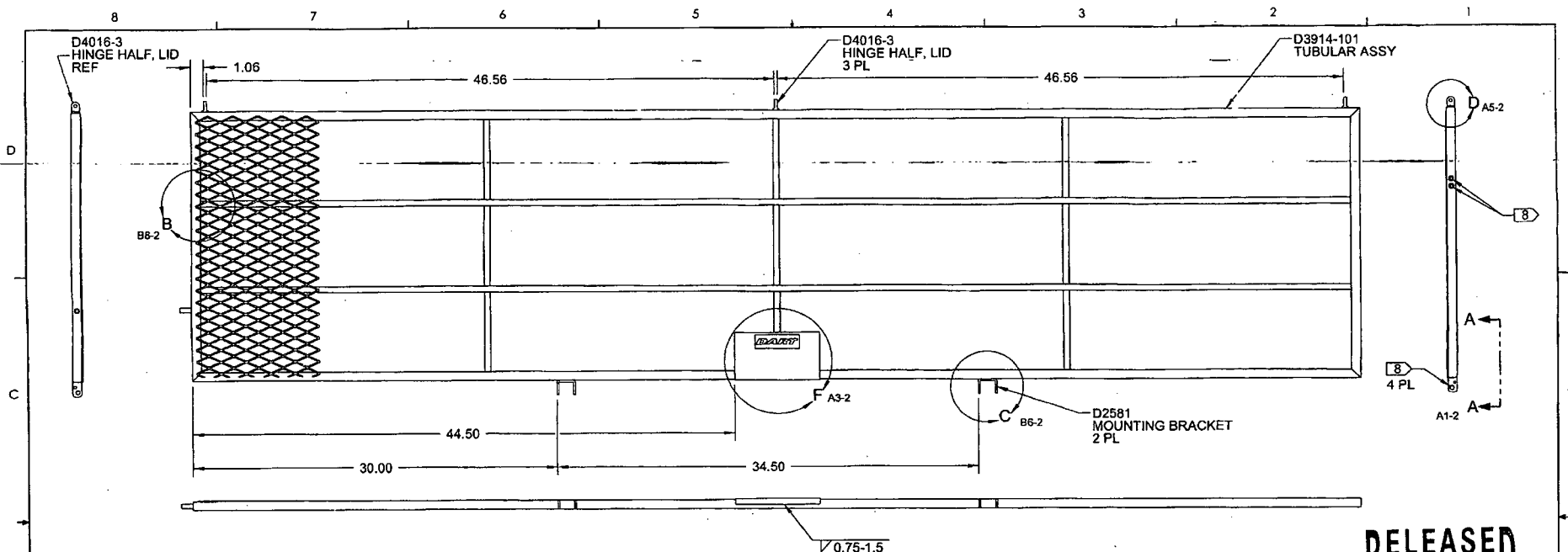
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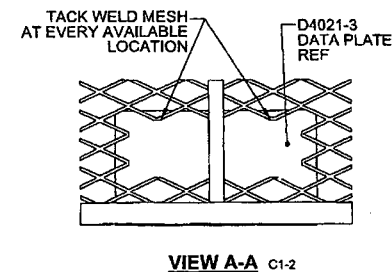
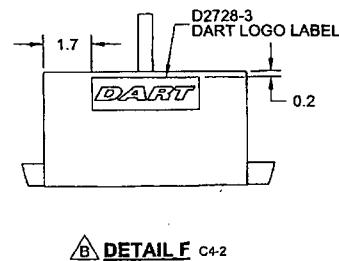
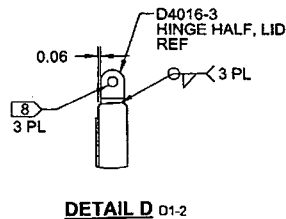
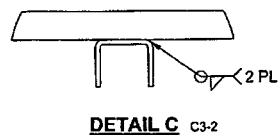
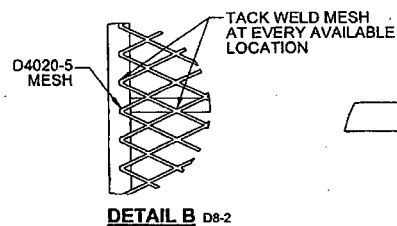
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NOTE: Date & initial all entries



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

wo 64029

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D3914	SHEET 2 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
10.08.12 *up*

W/O:		WORK ORDER CHANGES					
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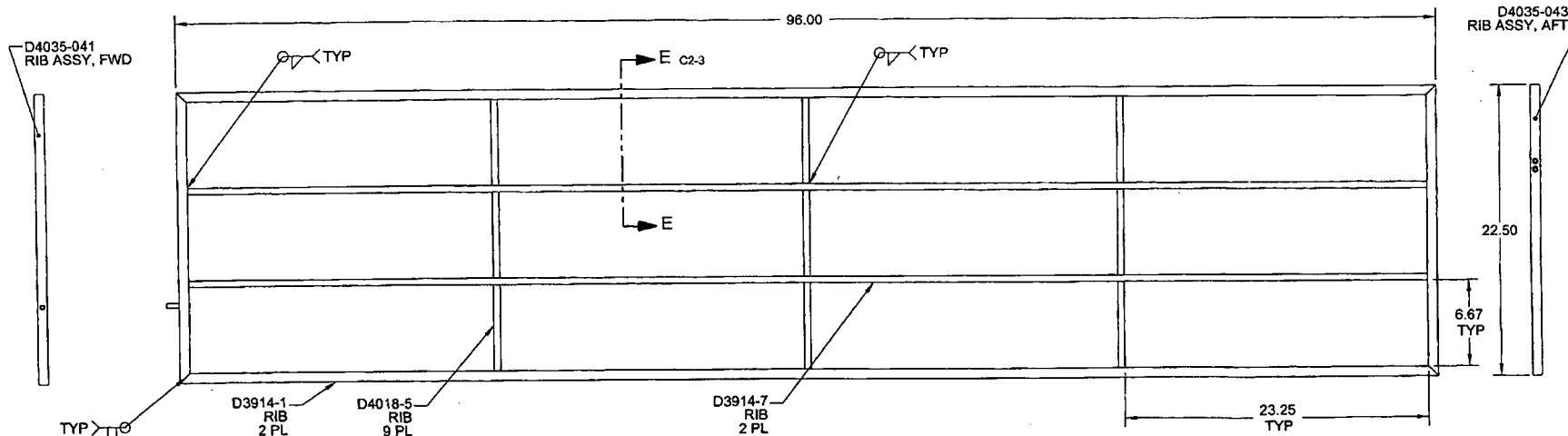
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10.08.12 CP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	TC	DRAWING NO.	REV. B
MFG. APPR.		D3914	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
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W/L 64629

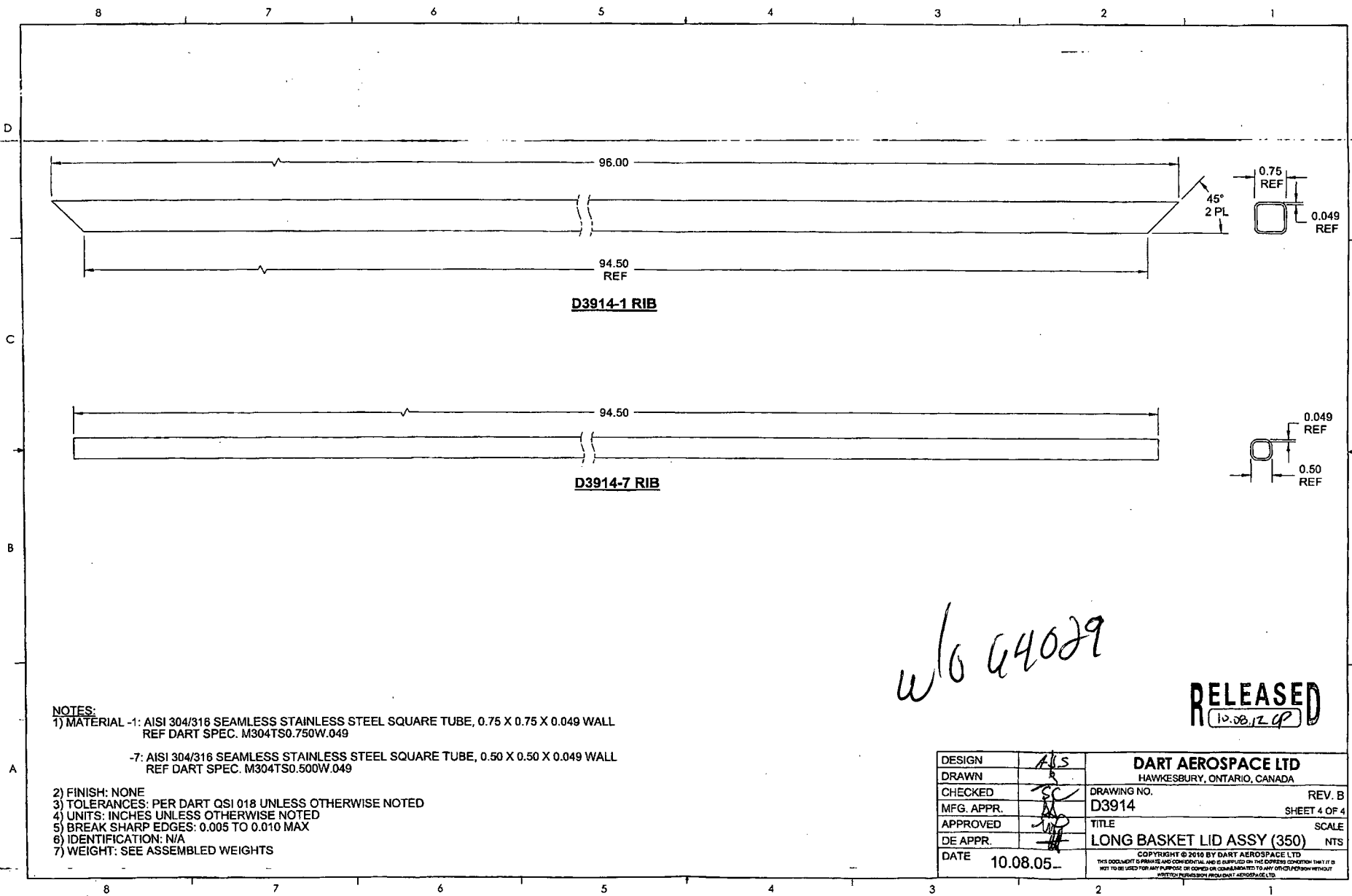
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W/O 64029

RELEASED
10.08.12.49

NOTES:

- 1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. D3914	REV. B
CHECKED	SC		SHEET 4 OF 4
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